

Date: Thursday, 08/03/2007 1:17:28 PM  
 User: Linda Lacelle

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 31031B		
Estimate Number	: 10841		
P.O. Number	: N/A	Part Number	: D22493
This Issue	: 08/03/2007	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Number	: D2249 REV. E
First Issue	: 07/03/2007	Project Number	: N/A
Previous Run	:	Drawing Revision	: E
Written By	:	Material	: N/A
Checked & Approved By	:	Due Date	: 10/04/2007
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF		
Qty: 10 Um: Each			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty: 0.1470 sf(s)/Unit Total: 1.4700 sf(s) 304/316 .063 Sheet Batch: M101463 - ml 07 03 14 (10)		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2249 Dwg Rev: E ml 07 03 14 (10) Prog Rev: E		
2-Deburr if necessary > ml 07/03/14 x10		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 07 03 14 (10)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK J07 03 14 10		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D2249 ml 07/03/14 x10		

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Drawing Name: LUG

Job Number: 31031B

Part Number: D22493

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP



Mo7/03/19 PO

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Welding

Frank

07-03-22

8.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE



Stock 03/03

Job Completion



U 07-03-23

Date: Wednesday, 3/7/2007 8:38:08 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	LUG		
Job Number	31031B					
Estimate Number	10841					
P.O. Number			Part Number	D22493		
This Issue	3/7/2007	S.O. No.	Drawing Number	D2249 REV. E		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type	Drawing Revision	E		
Previous Run			Material			
Written By			Due Date	4/10/2007	Qty:	10 Um: Each
Checked & Approved By	<u>ADT 03.07</u>					
Comment	Est: D 05.02.04 Added Step 9 KJ/RF					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  Comment: PURCHASING Issue P/O: _____ Email or ship DXF file to vendor Laser Cut D2249-3 as per Dwg D2249 Material release note required
2.0	D22493F	Base Plate  Comment: Qty.: 1.0000 U(s)/Unit Total : 10.0000 U(s) BASE PLATE
3.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK  Comment: DIMENSIONAL CHECK Inspect dimensions as per template D2249-3T3 & Dwg D2249
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1  Comment: LARGE FABRICATION RESOURCE 1 1- Debur any rough edges 2- Form D2249-3 using Jig D2249-3T4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:08 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31031B

Part Number: D22493

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

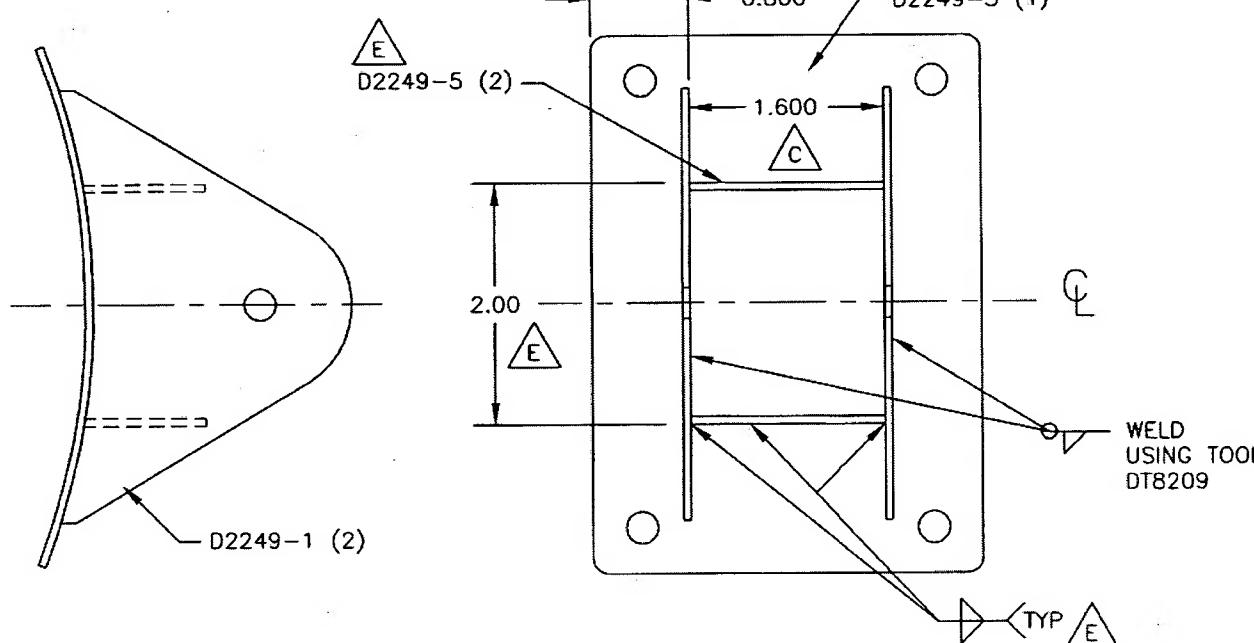
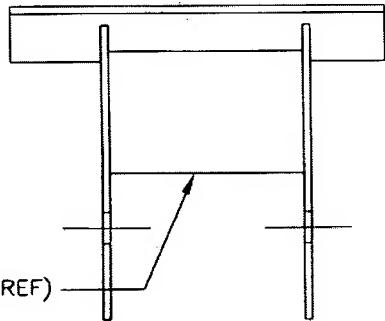
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**94.10.12  
KE

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED H	DRAWING NO. D2249	SHEET 1 OF 4
DATE 99.09.20	TITLE FITTING	SCALE NTS	
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14		
D	98.04.30	\$0.261 WAS \$0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	

D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK  
WELD PER DART QSI 004

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

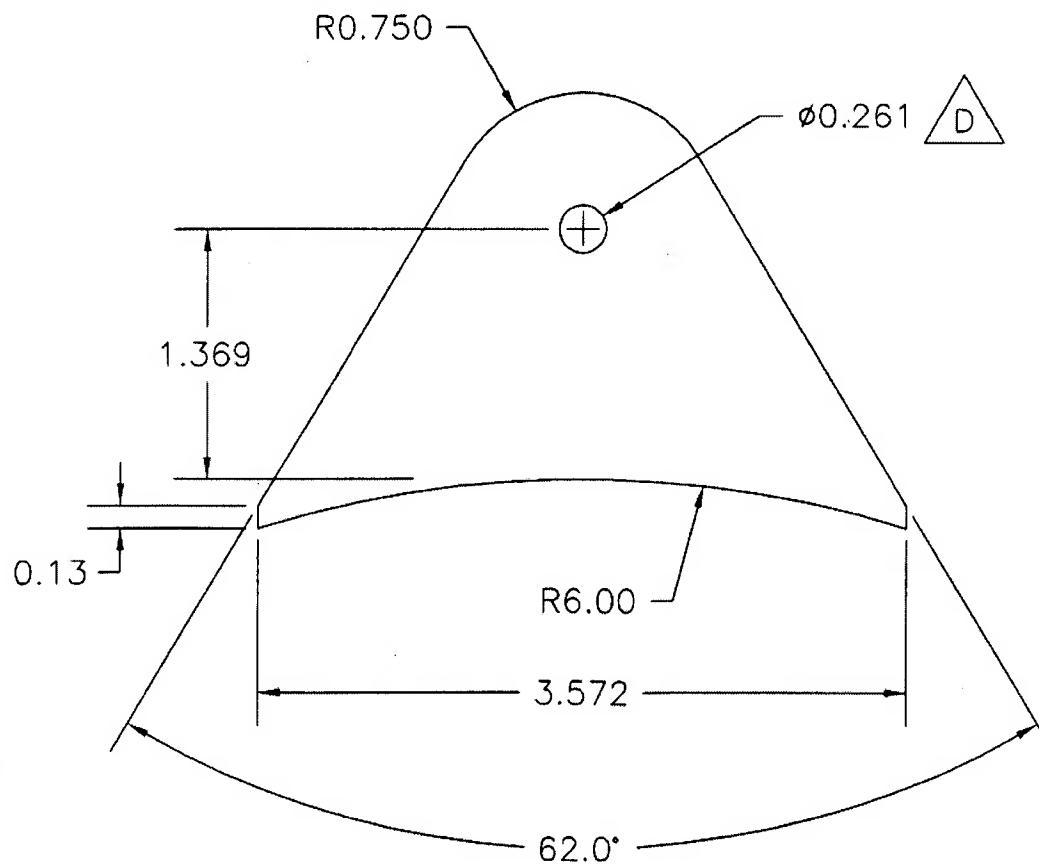
ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31031

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

**RELEASED**  
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31031B

**DART**COPY ISSUED  
DATE

DESIGN <i>RE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>M</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20	TITLE FITTING	SCALE 1:1	

**RELEASED**  
99.10.12 *KE*99.10.12 *KE*

4.44

3.690

0.375 (TYP)

0.400 (TYP)

2.400

3.20

FLAT PATTERND2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

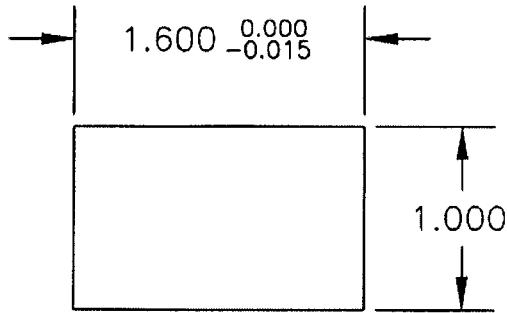
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL

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WITHOUT NOTICE  
WORK ORDER  
NO. 31031B

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

**RELEASED**  
99.10.12 KED2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *31031B*

DART AEROSPACE LTD	Work Order:	31031B
Description: Lug	Part Number:	D2249-3
Inspection Dwg: D2249 Rev: E		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## First Article      Prototype

<b>Measured by:</b>	<i>M. M.</i>	<b>Audited by:</b>	<i>J</i>	<b>Prototype Approval:</b>	<i>N/A</i>
<b>Date:</b>	<i>07 03 14</i>	<b>Date:</b>	<i>07 03 14</i>	<b>Date:</b>	<i></i>

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
		New Issue	KJ/JLM	